

54741 Deren

Work Order ID 53029

October 22, 2009 10:05:26 AM



Page 1

Item ID: D3363-1

Accept



Setup Start

Revision ID: C

Stop

Item Name: Console

Start Date: 21/10/2009 Start Qty: 4.00

Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan: *PL*Date: *09-10-27*

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3363

Rev C

100

0.00



FLOW WATER JET

Waterjet

0.00

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D3363 ***CUT AT 45 DEG GRAIN DIRECTION*****

6061

☐Dwg Rev: *C* ☐ Prog Rev: *C* ☐ 2-Deburr if necessary

.003

(4)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

0.00

Memo

Quality Control

AB 9-11-5

120

0.00



QC8- Inspect parts - second check

QC

0.00

Memo

Quality Control

2>807/10/05

(4)

Work Order ID 53029

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Item ID: D3363-1

Accept

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Item Name: Console

Start Date: 21/10/2009 Start Qty: 4.00

Required Date: 30/10/2009 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130



Brake NC

Brake NC

NC BRAKE

Memo

Deburr ☐ Form as per Dwg D3363

0.00

0.00

SB 09/12/15

4 0

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

278 09/12/15

278 0

150



Large Fab

Large Fab

Large Fab

Memo

1 - Weld using DT8790 as per Dwg D3363 and QSI 004

2-grind weld Flush as per Dwg

11/09/16

0.00

0.00

LP

11/09/16

Work Order ID 53029



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October 22, 2009 10:05:26 AM

Item ID: D3363-1

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Setup Start



Revision ID: C

Stop



Item Name: Console

Start Date: 21/10/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

4 0 BE 09/12/17

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

SD 09/12/17

44

171

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

MD 09/12/17

44

Work Order ID 53029

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Page 4

Item ID: D3363-1

Accept



Setup Start



Revision ID: C

Stop



Item Name: Console

Start Date: 21/10/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

172

QC3- Inspect Part Finish

0.00

BR 09-12-17

(4)



QC

Memo

0.00

Quality Control

180

Identify as per dwg & Stock Location: GA

0.00

SB 09/12/18

4



Packaging

Memo

0.00

Packaging

190

QC21- Final Inspection - Work Order Release

0.00

0.00



QC

Memo

Quality Control

09/12/18

WF 09-12-18

Picklist Print

October 22, 2009 10:05:31 AM

Page 1

Work Order ID: 53029

Parent Item: D3363-1RevC

Parent Item Name: Console


Comments:

Start Date: 21/10/2009

Required Date: 30/10/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			100	sf	233.2841	9.6842			
												
6061-T6 .063 Sheet												

B9-11-5

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

233.2841211

110551

33.2841211

112939

200

112939

DART AEROSPACE LTD		Work Order:	53029
Description: Console		Part Number:	D3363-1
Inspection Dwg: D3363 Rev: C		Page 2 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.990	+/-0.010	18.990	✓			
1.80	+/-0.030	1.795	✗			
6.390	+/-0.010	6.391	✓			
5.790	+/-0.010	5.799	✗			
4.475	+/-0.010	4.476	✗			
4.100	+/-0.010	4.100	✓			
2.725	+/-0.010	2.726	✗			
2.00	+/-0.030	1.998	✓			
6.363	+/-0.010	6.361	✓			
10.737	+/-0.010	10.740	✓			
11.206	+/-0.010	11.207	✗			
3.206	+/-0.010	3.205	✗			
3.675	+/-0.010	3.680	✗			

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	9-11-5	Date:	09/10/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	AS

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NO. 53029
W/C
DART

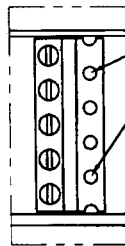
Rev 09-10-22

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. C
P11	PH		
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 3
PH	PH	D3363	
DATE	TITLE	SCALE	
07.01.26	CONSOLE ASSEMBLY	1:5	
A	04.11.29	NEW ISSUE	
B	05.03.28	INCREASE WIDTH BY 0.125	
C	07.01.26	T'DRILL DZUS RAIL, WIDEN BASE CUTOUT	

RELEASED

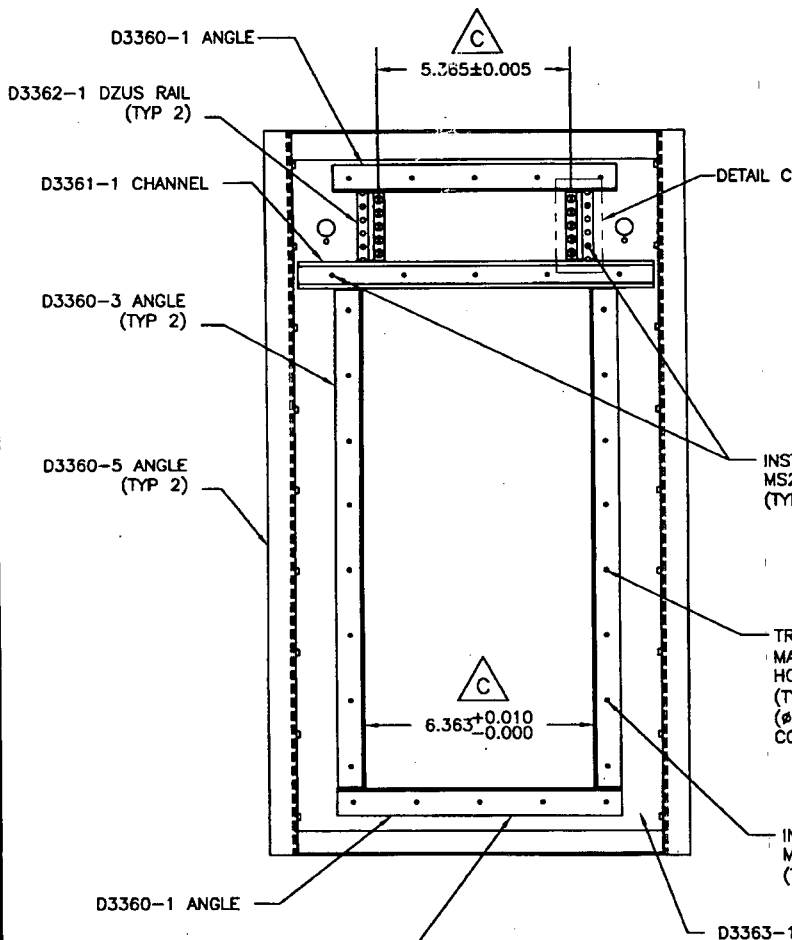
07.06.04

TRANSFER DRILL #30 FROM D3362-1 DZUS RAIL
THROUGH D3363-1 CONSOLE (TYP 4 PLACES)
C'SINK (#0.225 X 100')
FROM TOP SIDE OF CONSOLE



DETAIL C
(SCALE 1:2)

C'SINK THIS SIDE (REF)



DETAIL C

INSTALL D3361-1 & D3362-1 USING
MS20426AD4-6 RIVETS
(TYP 9 PLACES)

TRANSFER DRILL #30 FROM
MATING PARTS THROUGH #40
HOLES IN D3363-1 CONSOLE
(TYP 49 PLACES) C'SINK
(#0.225 X 100') FROM
CONSOLE TOP SIDE

INSTALL D3360-1/-3/-5 ANGLES USING
MS20426AD4-5 RIVETS
(TYP 44 PLACES)

PARTS LIST FOR D3363-041 CONSOLE ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
X	D3363-041	CONSOLE ASSEMBLY
2	D3360-1	ANGLE
2	D3360-3	ANGLE
2	D3360-5	ANGLE
1	D3361-1	CHANNEL
2	D3362-1	RAIL
1	D3363-1	CONSOLE
44	MS20426AD4-5	RIVET
9	MS20426AD4-6	RIVET

D3363-041 CONSOLE ASSEMBLY

- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 2) IDENTIFY WITH DART P/N D3363-041 AND B/N BXXXXX USING FINE POINT PERMANENT INK MARKER
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1



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DATE 07.01.26		TITLE CONSOLE ASSEMBLY	SCALE 1:4

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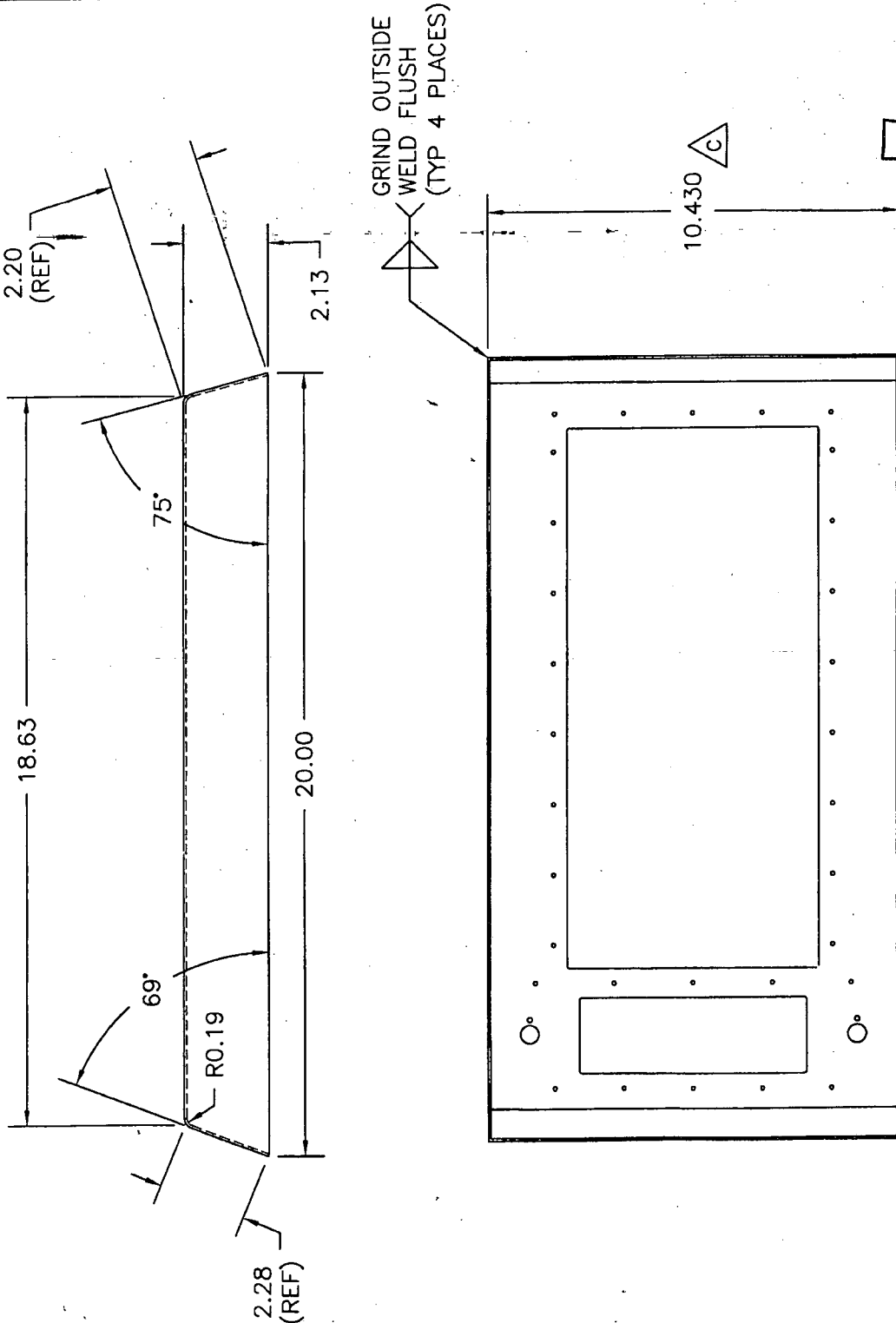
07.06.04 *PH*

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WORK ORDER
NO. 53089

D3363-1 BEND DETAIL
(MAKE FROM D3363-1F FLAT PATTERN)

D3363-1 CONSOLE

- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3363	REV. C SHEET 2 OF 3
DATE 07.01.26		TITLE CONSOLE ASSEMBLY	SCALE 1:4

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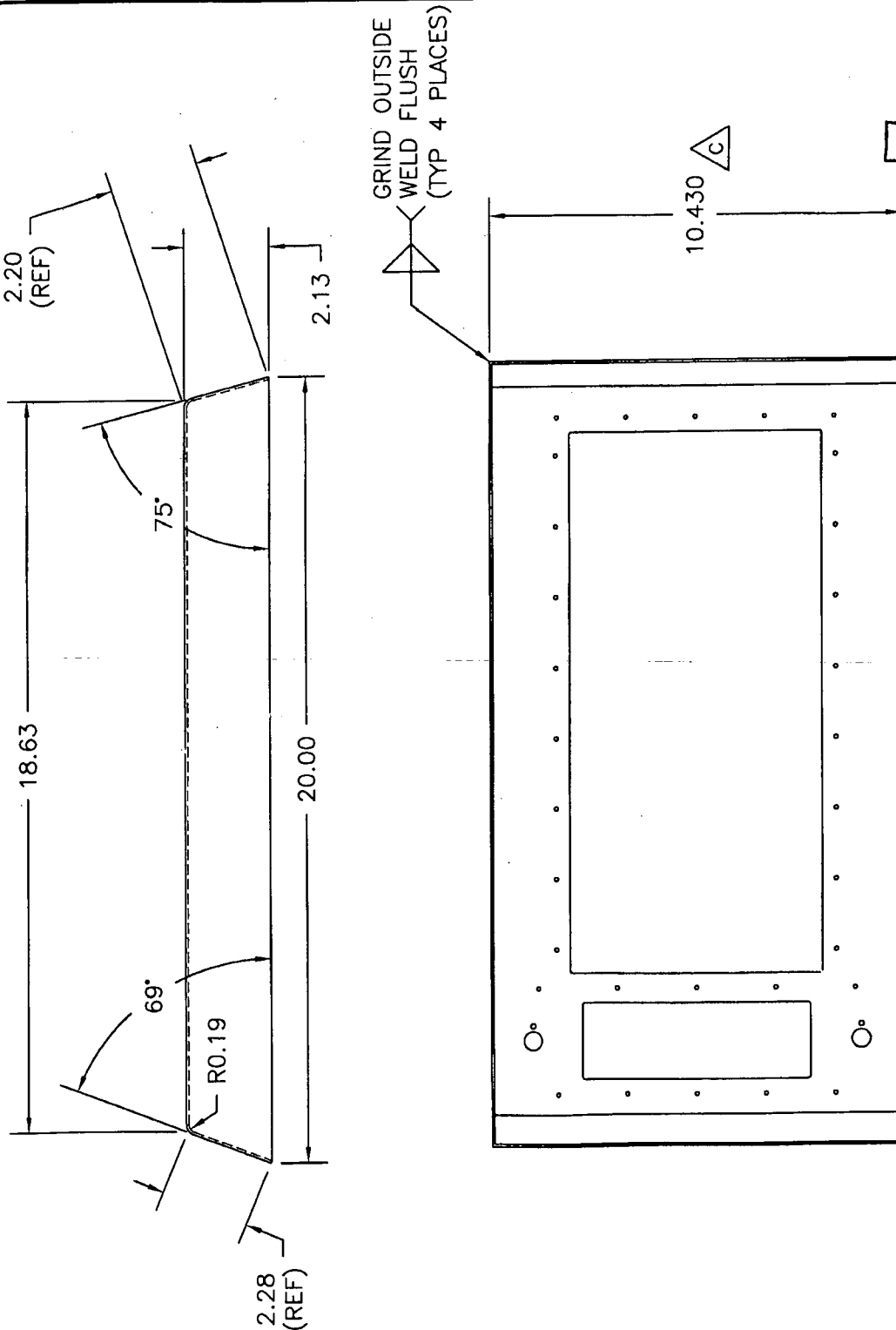
07.06.04 *PH*

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SHOP COPY

D3363-1 BEND DETAIL
(MAKE FROM D3363-1F FLAT PATTERN)

D3363-1 CONSOLE

- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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DART AEROSPACE LTD		Work Order:	53029
Description: Console		Part Number:	D3363-1
Inspection Dwg: D3363	Rev: C	Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

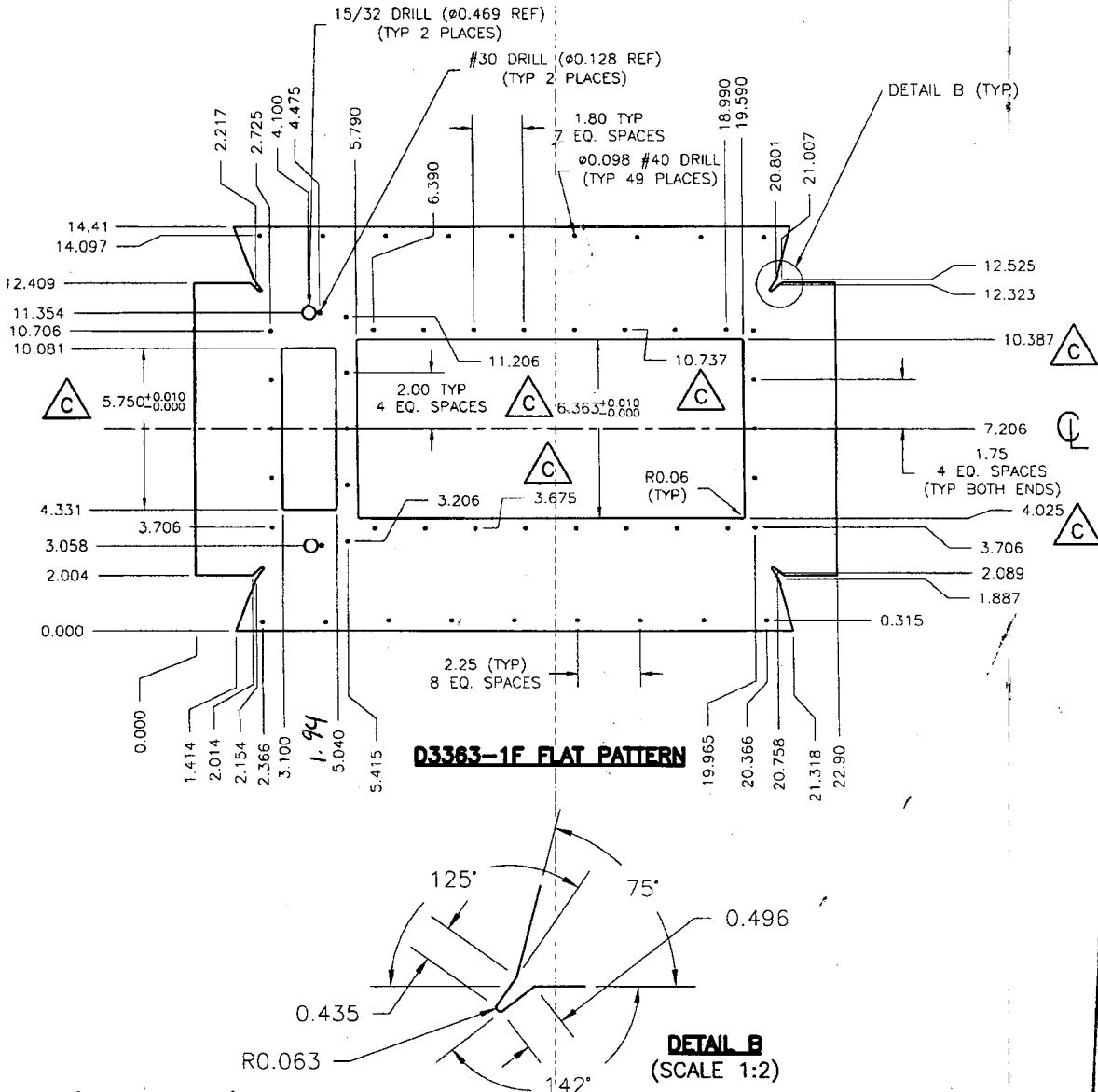
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.101	X			
Ø0.128	+0.005/-0.001	.132	X			
Ø0.469	+0.006/-0.001	.470	X			
14.41	+/-0.030	14.41	X			
14.097	+/-0.010	14.097	X			
12.409	+/-0.010	12.409	X			
11.354	+/-0.010	11.355	X			
10.706	+/-0.010	10.708	X			
10.081	+/-0.010	10.085	X			
4.331	+/-0.010	4.331	X			
3.706	+/-0.010	3.704	X			
3.058	+/-0.010	3.059	X			
2.004	+/-0.010	2.002	X			
2.366	+/-0.010	2.368	X			
3.100	+/-0.010	3.108	X			
5.040	+/-0.010	5.043	X			
5.415	+/-0.010	5.417	X			
2.25	+/-0.030	2.247	X			
19.965	+/-0.010	19.965	X			
20.366	+/-0.010	20.360	X			
21.318	+/-0.010	21.318	X			
22.90	+/-0.030	22.90	X			
0.315	+/-0.010	.317	X			
3.706	+/-0.010	3.707	X			
4.025	+/-0.010	4.029	X			
7.206	+/-0.010	7.209	X			
1.75	+/-0.030	1.750	X			
10.387	+/-0.010	10.388	X			
19.590	+/-0.010	19.590	X			

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
24	GH		
CHECKED	APPROVED	DRAWING NO.	REV. C
3		D3363	SHEET 3 OF 3
DATE		TITLE	SCALE
07.01.26		CONSOLE ASSEMBLY	1:6

07.06.04

53029



D.3363-1F CONSOLE (FLAT PATTERN)

- 1) MATERIAL: 6061-T6/T651 ALUMINUM 0.063 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS SYMMETRICAL ABOUT CENTERLINE

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